

Date: Thursday, 11/15/2007 1:27:15 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 SADDLE
Job Number : 35781	
Estimate Number : 12451	
P.O. Number :	Part Number : D35001
This Issue : 11/15/2007 S.O. No. :	Drawing Number : D3500 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 35315	Material :
Written By :	Due Date : 12/20/2007 Qty: 30 Um: Each
Checked & Approved By : <u>4071116</u>	
Comment : Est Rev: A New Issue 06-06-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6102013	6061-T6 7.0x6.5x2.0
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

6061-T6 7.0x6.5x2.0

350 Saddle Billet

Batch: 335605

DIP 08/03/26

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 35781 Double check by: LF

1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets

4-Deburr

5-Tumble to remove sharp edges.

DIP 08/03/26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/03/26

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 08/04/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 1:27:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 35781

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(30)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

08-04-01

6.0

POWDER COATING

POWDER COATING



(30X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.L. 08/04/01

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-04-02

(130)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST44/

4 times over stock
No more Room for the Saddle
we do need 08/04/02 (X3)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08-04-03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35781
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.490	.498	.500	.498		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.585	1.585	1.582	1.582		
J	0.240	0.260		.248	.250	.251	.252		
K	0.490	0.510		.499	.501	.499	.502		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.005	6.007	6.002	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.552	.554	.551	.552		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.136	1.136	1.133	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.258	.258	.257	.256		
AE	1.810	1.830		1.819	1.820	1.819	1.819		
AF	0.240	0.260		.254	.250	.251	.251		
AG	0.140	0.160		.149	.145	.146	.148		
AH	0.140	0.160		.151	.154	.148	.148		
AI	0.140	0.160		.149	.149	.151	.148		
Accept/Reject									

Measured by:	JL
Date:	08/03/27

Audited by:	SN
Date:	08/04/01

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	35781
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.496	.498	.500	.500		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.583	1.582	1.584	1.583		
J	0.240	0.260		.248	.253	.252	.250		
K	0.490	0.510		.501	.501	.501	.501		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		5.999	6.001	6.001	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.551	.552	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.133	1.133	1.134	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.252	.255	.256	.255		
AE	1.810	1.830		1.818	1.817	1.818	1.820		
AF	0.240	0.260		.247	.247	.249	.249		
AG	0.140	0.160		.146	.146	.146	.147		
AH	0.140	0.160		.148	.148	.148	.148		
AI	0.140	0.160		.149	.149	.150	.151		
Accept/Reject									

Measured by:	J.L
Date:	08/03/28

Audited by:	SN
Date:	08/04/01

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	35781
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.483	0.490		0.487	0.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.151	3.150		
D	1.175	1.185		1.180	1.179	1.178	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.496	0.494	0.495	0.495		
H	R.470	R.530		0.525	0.525	0.525	0.525		
I	R1.575	R1.595		1.588	1.588	1.587	1.588		
J	0.240	0.260		0.247	0.2465	0.247	0.247		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		0.320	0.320	0.320	0.320		
N	0.256	0.262		0.259	0.259	0.259	0.259		
O	6.500	6.520		6.508	6.508	6.508	6.508		
P	5.990	6.010		6.006	6.006	6.006	6.006		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.499	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.124	1.124	1.124	1.125		
U	0.540	0.560		0.550	0.553	0.553	0.555		
V	0.793	0.803		0.800	0.800	.800	0.800		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.055	0.055	0.055	0.055		
Y	0.100	0.120		0.110	0.110	0.110	0.108		
AA	R1.125	R1.145		1.138	1.138	1.137	1.1375		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.635	0.635	0.635		
AD	0.240	0.260		0.255	0.255	0.255	0.255		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.255	0.255	0.255	0.2545		
AG	0.140	0.160		0.151	0.150	0.150	0.150		
AH	0.140	0.160		0.152	0.151	0.151	0.151		
AI	0.140	0.160		0.151	0.150	0.150	0.150		
Accept/Reject									

Measured by:	DJP
Date:	08/03/26

Audited by:	SD
Date:	08/04/01

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	35781
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.484	.484	.487	.487		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.492	.500	.497	.496		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.585	1.585	1.587	1.587		
J	0.240	0.260		.250	.250	.250	.248		
K	0.490	0.510		.500	.500	.501	.499		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	5.999	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.551	.551	.552		
V	0.793	0.803		.800	.800	.800	.800		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.137	1.136		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.257	.257	.255	.257		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.251	.251	.256	.253		
AG	0.140	0.160		.152	.152	.151	.151		
AH	0.140	0.160		.150	.153	.151	.152		
AI	0.140	0.160		.149	.151	.151	.150		
Accept/Reject									

Measured by:	J.F.
Date:	08/03/27 / 08/03/27

Audited by:	SD
Date:	08/04/01

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	35781
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.499	.502	.501		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.587	1.586	1.587	1.586		
J	0.240	0.260		.249	.248	.249	.250		
K	0.490	0.510		.501	.502	.502	.502		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.001	6.002	6.002	6.002		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.551	.551	.551		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.137	1.136	1.137	1.137		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.252	.250	.252	.251		
AE	1.810	1.830		1.820	1.820	1.818	1.819		
AF	0.240	0.260		.249	.248	.249	.249		
AG	0.140	0.160		.151	.150	.151	.150		
AH	0.140	0.160		.147	.145	.144	.145		
AI	0.140	0.160		.148	.146	.148	.146		
Accept/Reject									

Measured by:	J.L
Date:	08/03/28

Audited by:	SD
Date:	08/04/01

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	35781
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1 25	2 26	3 27	4 28	By	Date
A	0.483	0.490		0.487	0.487	0.487	0.487		
B	1.175	1.185		1.1775	1.1775	1.178	1.178		
C	3.145	3.155		3.148	3.148	3.148	3.148		
D	1.175	1.185		1.1785	1.1788	1.1775	1.178		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.5005	0.500	0.500	0.500		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.586	1.592	1.589	1.585		
J	0.240	0.260		0.245	.245	0.248	0.247		
K	0.490	0.510		0.499	0.501	0.501	0.501		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		0.320	0.320	.320	0.320		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.513	6.513	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.498	2.499	2.499		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.124	1.124	1.124	1.125		
U	0.540	0.560		0.552	0.5515	0.552	0.550		
V	0.793	0.803		0.800	0.800	0.800	0.800		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.055	0.055	0.055	0.055		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.136	1.142	1.1385	1.1348		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.245	0.246	0.250	0.252		
AE	1.810	1.830		1.818	1.822	1.822	1.820		
AF	0.240	0.260		0.248	0.2525	0.253	0.252		
AG	0.140	0.160		0.151	0.155	0.156	0.154		
AH	0.140	0.160		0.148	0.150	0.149	0.148		
AI	0.140	0.160		0.150	0.145	0.149	0.149		
Accept/Reject									

Measured by:	DJP
Date:	08/03/29

Audited by:	SD
Date:	08/04/01

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	35781
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
				29	30				
A	0.483	0.490		.487	0.487				
B	1.175	1.185		1.178	1.178				
C	3.145	3.155		3.149	3.149				
D	1.175	1.185		1.1775	1.178				
E	0.365	0.385		0.375	0.375				
F	0.490	0.510		0.501	0.501				
H	R.470	R.530		.500	.500				
I	R1.575	R1.595		1.589	1.5845				
J	0.240	0.260		0.246	0.248				
K	0.490	0.510		0.501	0.501				
L	3.590	3.650		3.625	3.625				
M	0.315	0.320		.320	.320				
N	0.256	0.262		.259	.259				
O	6.500	6.520		6.511	6.511				
P	5.990	6.010		6.000	6.000				
Q	2.820	2.830		2.825	2.825				
R	2.495	2.505		2.499	2.499				
S	2.245	2.255		2.2485	2.249				
T	1.120	1.130		1.124	1.124				
U	0.540	0.560		0.546	0.546				
V	0.793	0.803		0.800	0.800				
W	R.240	R.260		.250	.250				
X	0.040	0.060		0.055	0.055				
Y	0.100	0.120		0.105	0.105				
AA	R1.125	R1.145		1.1385	1.134				
AB	R.490	R.510		0.500	.500				
AC	0.615	0.635		0.635	0.635				
AD	0.240	0.260		0.2525	0.2525				
AE	1.810	1.830		1.820	1.820				
AF	0.240	0.260		0.252	0.252				
AG	0.140	0.160		0.1505	0.151				
AH	0.140	0.160		0.149	0.149				
AI	0.140	0.160		0.153	0.153				
Accept/Reject									

Measured by:	DJP
Date:	08/03/30

Audited by:	SA
Date:	08/07/01

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	<i>[Signature]</i>

